

Date: Friday, 11/04/2008 9:02:29 AM  
 User: Julie Lecocq

## Process Sheet

|   |   |
|---|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b> : PLUG                                  |
| <b>Job Number</b> : 38562                             |   |
| <b>Estimate Number</b> : 12322                        |   |
| <b>P.O. Number</b> :                                  | <b>Part Number</b> : D3492041                               |
| <b>This Issue</b> : 11/04/2008 <b>S.O. No.</b> :      | <b>Drawing Number</b> : D3492 REV C                         |
| <b>Prsht Rev.</b> : NC                                | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS | <b>Drawing Revision</b> : C                                 |
| <b>Previous Run</b> : 38182                           | <b>Material</b> :   |
| <b>Written By</b> :                                   | <b>Due Date</b> : 30/04/2008 <b>Qty:</b> 60 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> :                    |   |
| <b>Comment</b> : est rev A 06.03.03 New Issue EC      |   |
| Est Rev:B 06-08-28 As per Rev B JLM                   |   |
| Est Rev:C 07-12-06 Rev C dwg DD                       |   |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |              |                         |
|-----|--------------|-------------------------|
| 1.0 | M6061T6R0625 | 6061-T6 Round Bar .625" |
|-----|--------------|-------------------------|



**Comment:** Qty.: 0.0656 f(s)/Unit Total : 3.9375 f(s)  
 6061-T6 Round Bar .625"  
 (M6061T6R0625)  
 Batch: M107513

(60)

MMF 08/04/13

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 & Dwg D3492  
 Dwg Rev: B  
 Folio Rev: AA

MMF 08/04/13

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MMF 08/04/13

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

MMF 08/04/13

MMF 08/04/13

(60)

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if neccesay

N/A MMF 08/04/13

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 11/04/2008 9:02:29 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 38562

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-21

(60)

B38562

D3492041  
29/04/2008

S.145

10.18

#1

#2

#3

#4

19.9 F  
30 mins F  
F

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

M107550

BR 08-04-29

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-04-29

(60)

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING  
(or MS28775-010)

M100589

BR/RP

08-05-01

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

1- Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube  
A/R 55-O'Ring Lube Batch: M101223

BR/RP

08-05-01

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E. adalsty

(60)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

F-P-1

M-1

08/05/01

(60X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 11/04/2008 9:02:29 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 38562

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/05 [Signature]

Job Completion



MF 08-05-02.

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



8

7

6

5

4

3

2

1

D3492-XX PLUG  
(SEE TABLE)NAS1611 PLUG  
(SEE TABLE)**D3492-XXX PLUG PARTS LIST**





| QTY<br>-041 | QTY<br>-043 | QTY<br>-045 | QTY<br>-047 | QTY<br>-049 | QTY<br>-051 | QTY<br>-053 | PART NUMBER | DESCRIPTION   |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X           |             |             |             |             |             |             | D3492-041   | PLUG ASSEMBLY |
|             | X           |             |             |             |             |             | D3492-043   | PLUG ASSEMBLY |
|             |             | X           |             |             |             |             | D3492-045   | PLUG ASSEMBLY |
|             |             |             | X           |             |             |             | D3492-047   | PLUG ASSEMBLY |
|             |             |             |             | X           |             |             | D3492-049   | PLUG ASSEMBLY |
|             |             |             |             |             | X           |             | D3492-051   | PLUG ASSEMBLY |
|             |             |             |             |             |             | X           | D3492-053   | PLUG ASSEMBLY |
| 1           |             |             |             |             |             |             | D3492-1     | PLUG          |
|             | 1           |             |             |             |             |             | D3492-3     | PLUG          |
|             |             | 1           |             |             |             |             | D3492-5     | PLUG          |
|             |             |             | 1           |             |             |             | D3492-7     | PLUG          |
|             |             |             |             | 1           |             |             | D3492-9     | PLUG          |
|             |             |             |             |             | 1           |             | D3492-11    | PLUG          |
|             |             |             |             |             |             | 1           | D3492-13    | PLUG          |
|             |             | 1           |             |             |             |             | NAS1611-005 | O-RING        |
|             |             |             | 1           |             |             |             | NAS1611-007 | O-RING        |
| 1           |             |             |             |             |             |             | NAS1611-010 | O-RING        |
|             |             |             |             |             |             | 1           | NAS1611-012 | O-RING        |
|             | 1           |             |             |             |             |             | NAS1611-013 | O-RING        |
|             |             |             |             |             | 1           |             | NAS1611-015 | O-RING        |
|             |             |             |             | 1           |             |             | NAS1611-016 | O-RING        |

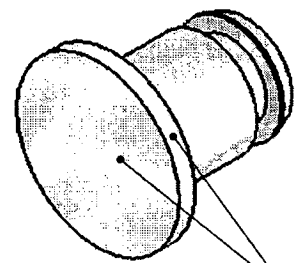
**NOTES:**

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

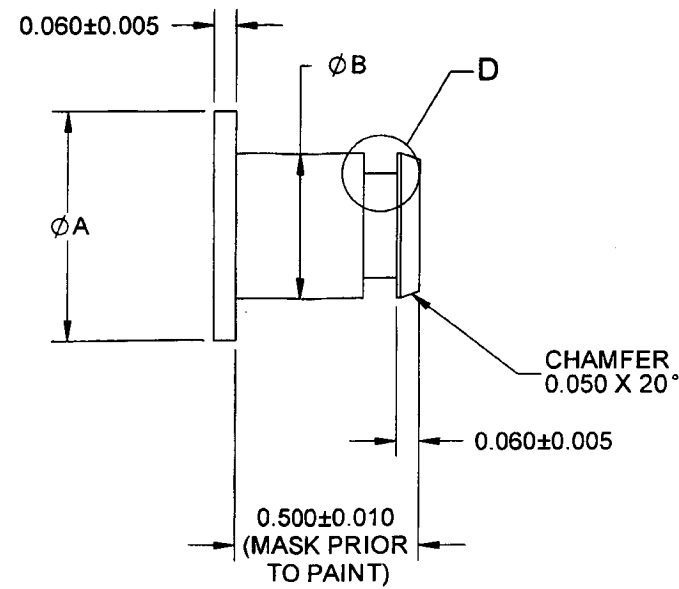
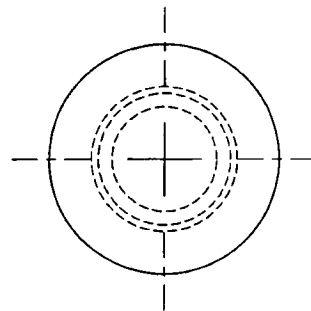
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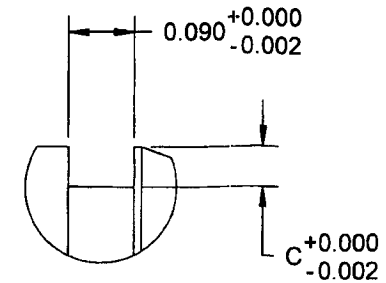
|            |   |   |          |
|------------|---|---|----------|
| C          | ADD -049/-051/-053, CHANGE DRAWING FORMAT   | PH  | 07.10.05 |
| B          | ADD -047; UPDATE DIM A FOR -045   | PH  | 06.05.11 |
| A          | NEW ISSUE   | PH  | 06.01.04 |
| REV.       | DESCRIPTION   | BY  | DATE     |
| DESIGN     |  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |          |
| DRAWN      |  |   |          |
| CHECKED    |  |   |          |
| MFG. APPR. |   |   |          |
| APPROVED   |   |   |          |
| DE APPR.   |  | DRAWING NO. REV. C<br>D3492 SHEET 1 OF 2  |          |
| DATE       | 07.10.05  | TITLE SCALE<br>PLUG 2:1   |          |
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POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

| P/N      | A     | B     | C     | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-1  | 0.625 | 0.394 | 0.055 | M6061T6R0.625 |
| D3492-3  | 0.750 | 0.582 | 0.045 | M6061T6R0.750 |
| D3492-5  | 0.375 | 0.188 | 0.045 | M6061T6R0.375 |
| D3492-7  | 0.500 | 0.270 | 0.045 | M6061T6R0.500 |
| D3492-9  | 0.938 | 0.750 | 0.045 | M6061T6R1.000 |
| D3492-11 | 0.850 | 0.664 | 0.045 | M6061T6R0.875 |
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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WORK ORDER  
NO. 38560

**RELEASED**  
07.11.16

|            |                 |  |              |
|------------|-----------------|--|--------------|
| DESIGN     |                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      |                 |  |              |
| CHECKED    |                 | DRAWING NO.  | REV. C       |
| MFG. APPR. |                 | <b>D3492</b>   | SHEET 2 OF 2 |
| APPROVED   |                 | TITLE  | SCALE        |
| DE APPR.   |                 | <b>PLUG</b>  | 4:1          |
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